## Work Order ID 100737

May 1, 2013 7:06:52 AM

\*100737\*

Page 1

Item ID: Revision ID: Item Name:	D4021-5 Blanking Plate	e		Accept	*N900040100	)*	Setup Sta	147.2.1
Start Date: Required Date Reference:	5/06/13 : 5/06/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item ID: Customer:			
Approvals:	Process Pla	an:	Date: <i> 3-03- </i> Date:	Tooling: SPC (Y/N):	Date:	1	Run Sta	"NRT"
Seq Work Center		Description -		seft.p/ Rus Hours	Vent# Pien Code	er ge Obj	Reject	Nejec. 185. Numbe. Jamp
Draw Nbr D4021 100 *100* Waterjet FLOW CNC Water 304-063	B	Memo Cut as per d Prog Rev:_ Dwg Rev:_	wg D4021	0.00		6	6	JMB-5-30
*110 *110* QC Quality Control		Deburr as re QC2- Inspect parts off n  Memo		0.00 .	·	6	O	Jm 13-5-30

									DQA:	Date:	
NCR: \	Yes / No				WORK ORDER NON-	CONFOR	MANCE / UI	PDATE		5	
<del></del>									QA Closed:	Date:	White come is a second control of the control of th
Work Orde	ar.				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
WOIK Olde	JI,			<del></del>	Rework	7 <b> </b>	Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	No.				Scrap	1 1	Machining	Small Fab	Pro	od. Eng. Coor.	Quality
			-		Use-as-is	Ther	moforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	No			<del></del>	Work Order Update		Large Fab	Composite	_	Supplier	
Root				Descri	ption of work order update	Initial	A	ction	Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Chief En	g Des	cription	Date	Verification	QC inspector
Doc/Data					,						
Equip/Tooling											
Operator									Ì		
Material	·	1			•	-					
Setup				•							
Other			]		٠.						
Process		ŀ			•						
Supplier											
Training											
Unapproved						1				<u> </u>	<u> </u>
					<u> </u>	<b>AULT CAT</b>				· ·	
Landir	ng Gear				General				7		·
	Bending				Bend	Grain			Ovalized	<u> </u>	Pressure/Forced
	Centre N	ot Conce	ntric to (	D/S	BOM/Route	Hardv		ļ <u>.</u>	Over/Under	<b>⊢</b>	Temperature/Cure
	Cracks				Broken/Damaged	_	ction Incomplete	_	Part Incorre	<u> </u>	Weld
	Crushed,	/Crimped	-		Burrs	<b>—</b>	ctions Incomplete	e/Unclear	Part Lost/N		Wrong Stock Pulled
	Cuffs				Contamination	<u> </u>	tenance		Part Moved		
	Heat Tre	at			Countersink	Mislal	peled		Positioned '		7
	Inspection	on Strip in	Tube		Cut Too Short	Misre	ad		Power Loss	/Surge	Other
	Ripples in	n Bend			Drill Holes	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

## Work Order ID 100737

May 1, 2013 7:06:52 AM

Required Date: 5/06/13

\*100737\*

Item ID:

D4021-5

**Revision ID:** 

Item Name:

Blanking Plate

**Start Date:** 

5/06/13

OC:

Start Qty: 6.00

Req'd Qty: 6.00

Reference:

**Approvals:** 

**Process Plan:** 

Date: Date:

**Tooling:** 

Accept

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Tool # Plan

Code

Cust Item ID:

**Customer:** 

Tooi H

\*N900040100\*

Run

Qty

Setup Start

Section 111

Work Center 1D

120

\*120\*

QC

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

0.00 0.00

B.S31

Reject

-Reject Number

hap. Stamp

Accept

Qty.

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

\*130\* Powdercoat

Powder Coating

135

Quality Control

Memo

QC3- Inspect Part Finish

Memo

512-17:me , 9:00 10emp , 40001= Finish Time, 9:30

0.00

0.00

										DQA:	Date	:
NCR: Y	es / No				WORK ORDER NON-C	CONF	ORN	MANCE / UPDATE				
	,		<del></del>					Company of the Compan		QA Closed:	Date	•
Work Orde	\r.				DISPOSITION			AGAINS'	T DE	PARTMENT	PROCESS	
Work Orde	:		<del></del>	<del></del>	Rework	1		Skid-tube Crosstube	۔ ا		Water Jet	Engineering
Part N	lo.		•		Scrap			Machining Small Fal	_	Pro	d. Eng. Coor.	Quality
					Use-as-is	1   7		oforming Finishin	g	Rec/Stor	re/Packaging	Other
NCR N	lo				Work Order Update	]		Large Fab Composite	e		Supplier	
Root	<del></del> T	Ī	1	Descri	ption of work order update	Init	ial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief	1	Description	•	Date	Verification	QC Inspector
Doc/Data												
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Operator											-	·
Material												
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Other												
Process [			•									
Supplier [												
Training										'		
Unapproved							l			<u> </u>	L	
	400		<u> </u>		F.	AULT (	CATE		18950			r.
Landir	ng Gear	•		·	General		-	top 🎒 📝 man 🖟	् <sub>षिक</sub>			N two
1	Bending			<u></u>	Bend	<b>—</b>	rain		·Ŀ	Ovalized	<u> </u>	Pressure/Forced
ļ	Centre N	ot Conce	ntric to (	D/S	BOM/Route	<del></del>	ardwai		_	Over/Under	<b> </b>	Temperature/Cure
	Cracks			ļ	Broken/Damaged	_		on Incomplete	-	Part Incorre	<del>-</del>	Weld
	Crushed/	Crimped.		-	Burrs	-		ons Incomplete/Unclear	-	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs			_	Contamination	1		nance 	-	Part Moved		
1	Heat Trea			<u> </u>	Countersink		islabe		-	Positioned V	_	700
1	Inspectio	•	Tube	ļ	Cut Too Short		isread		L	Power Loss/	Surge	Other
i	Ripples ir	n Bend			Drill Holes	01	ffset					

Out of Calibration

Outside Dimensions

Out of Sequence

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

May 1, 2013 7:06:52 AM

Item ID:

D4021-5

Accept

\*N900040100\*

Setup Start

**Revision ID:** 

**Start Date:** 

Item Name: Blanking Plate

Required Date: 5/06/13

5/06/13

Start Qty: 6.00 Reg'd Qty: 6.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

**Process Plan:** 

Date:

Tooling:

i- of 1D

Date:

Run

Start

OC:

Date:

SPC (Y/N):

Date:

Too!#

Accept

Qty

Reject Reject Qty

Stop

lasp. Number Stamp

Sequence 10/ Work Center ID 2.3234.0"11.635.es.

Description

Identify as per dwg & Stock Location: 57084

Set Up/ kun Hours

0.00

\*140\*

Packaging

Packaging

Memo

0.00

6X

Plan

Code

MILO. 13-05-31

150

140

QC21- Final Inspection - Work Order Release

0.00

\*150\*

Quality Control

Memo

0.00

mes 13:05:31

A 4 4 - 50

								DQA:	Date:	
NCR: Yes	s / No			WORK ORDER NON	N-CONFOF	RMANCE / UF		QA Closed:	Date:	
Work Order:		· · · · · ·		DISPOSITION	DISPOSITION AGAINST DE					
Part No.				·	Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing		Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other	
NCR No	•			Work Order Update		Large Fab	Composite	·	Supplier	
Root				Description of work order update	Initial	A	ction	Sign &		
Cause	Date	Step	Qty	or Non-conformance	Chief En	g Des	cription	Date	Verification	QC Inspector
Doc/Data										
quip/Tooling		,								
Operator						1		į		
Material						İ				
Setup										1
Other									<u> </u>	
Process										
Supplier										
raining										
Inapproved						1				

**FAULT CATEGORY** 

General **Landing Gear** Grain Pressure/Forced Bend Ovalized Bending Temperature/Cure BOM/Route Over/Under tolerance Centre Not Concentric to O/S Hardware Weld Broken/Damaged Inspection Incomplete Part Incorrect Cracks Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped. Burrs Maintenance Part Moved Cuffs Contamination Positioned Wrong Mislabeled Heat Treat Countersink Other Power Loss/Surge Cut Too Short Misread Inspection Strip in Tube Drill Holes Offset Ripples in Bend Out of Calibration Torque Waves in Extrusion Drawing Out of Sequence Finish Turning Sequence Folio **Outside Dimensions** Wave/Twist in Tube

## **Picklist Print**

May 1, 2013 7:06:52 AM

Work Order ID:

100737

Parent Item:

D4021-5

Parent Item Name:

Blanking Plate

**Start Date:** 5/06/13

Required Date: 5/06/13

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP RevA: new issue DD 09.11.25 verified by:EC IPP Rev:B as per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB DD 10.04.20 verified by:EC

			···o us pe	. ang tetb bb	10.01.20	crimed by .ibc							
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	268.4214	0.0622	<del>0.39</del> 28422 0.4		j	Jm13-5-20
				<b>Location</b>		Loc Qty	Lo	c Code					
				P.1 (14.7)		25c / 488							
				12727		4681							
				12313	io	146.8	,						
	•			12442	28	29							
				12457	72	98.45			124	157a.			

Page 1

			D	QA:	Date:
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE		

IVCN. I	63	/ NO					WORK ORDER WORK		· On	mutce, or		QA Closed:	Date:	
Work Orde	r:	,			<del></del>		DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
Part N	0						Rework Scrap		ſ	Skid-tube Machining	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	o						Use-as-is Work Order Update						Supplier	
Root	T				Des	crip	otion of work order update	Ī	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		O	r Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
oc/Data														
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								AUL	T CATE	GORY		` .		
Landir	_			•	ſ		General	<u></u>	1		<u>.</u>	٦, , ,	[-	Pressure/Forced
}		Bending			.		Bend	<u> </u>	Grain		-	Ovalized	A-1	Temperature/Cure
-		Centre No	ot Concer	itric to (	O/S		BOM/Route		Hardwa		<u> </u>	Over/Under	<del></del>	Weld
ŀ		Cracks					Broken/Damaged	-	1 '	on Incomplete	Lindan	Part Incorred	<del></del>	Wrong Stock Pulled
-	_	Crushed/0	Crimped.				Burrs	$\vdash$	4	ions Incomplete/	Unclear	Part Lost/Mi	ssing [_	JWrong Stock Fulled
-		Cuffs					Contamination	$\vdash$	Mainte		·	Part Moved	Vrong	
}	Heat Treat				Countersink	$\vdash$	Mislabe		-	Positioned V Power Loss/		Other		
}	Inspection Strip in Tube				Cut Too Short	-	Misread	ג	L	Trower ross/	Juige	Other		
}	——	Ripples in					Drill Holes	-	Offset	Calibration	ate say			
				Drawing	Out of Calibration Out of Sequence									
}	Turning Sequence					Finish	-	1	•					
	Wave/Twist in Tube					Folio	i .	Outside	Dimensions					

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DART AEROSPACE LTD	Work Order:	100137
Description: Blanking Plate	Part Number:	D4021-5
Inspection Dwg: D4021 Rev: B		Page 1 of 1

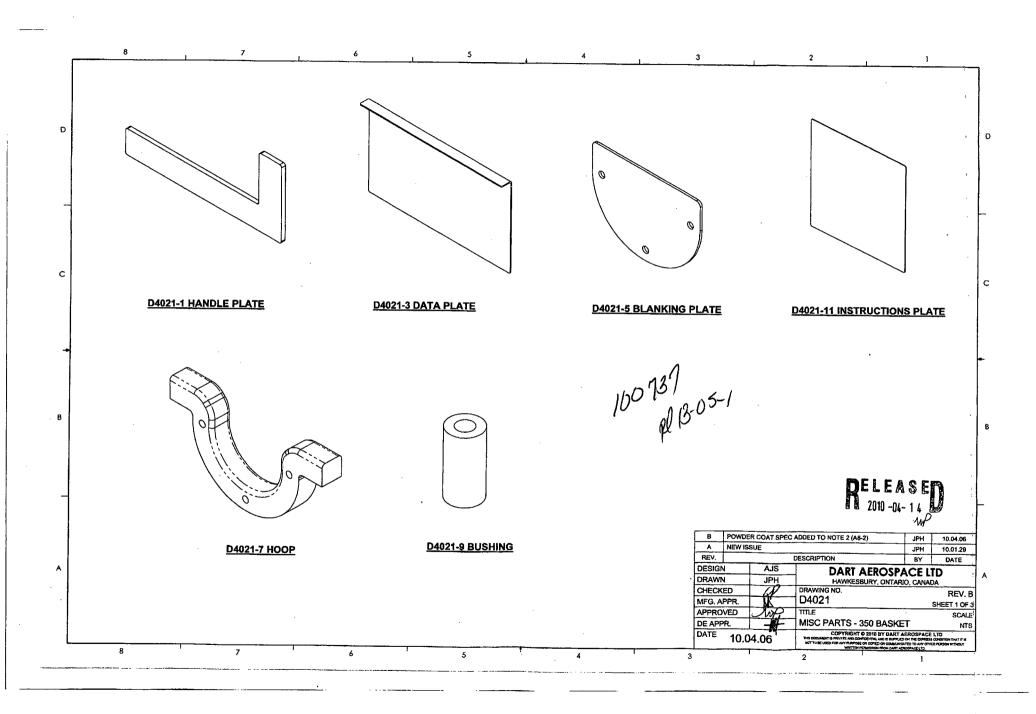
## FIRST ARTICLE INSPECTION CHECKLIST

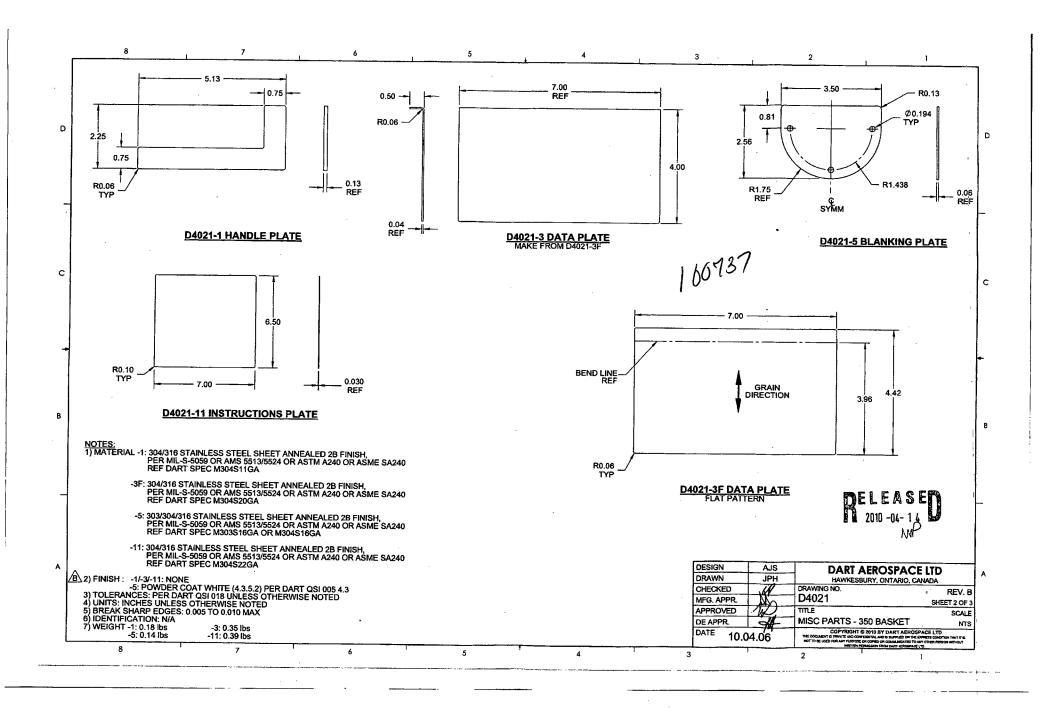
х	First Article	Prototype
	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.194	+0.005/-0.001	A 1911"	_		V	JEMOB
3.50	+/-0.030	3 503	_		V	241.00
2.56	+/-0.030	3.503° 2-564° 0.812°			v	
0.81	+/-0.030	0.812"	_	<del></del>	V	
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Measured by:	Im	Audited by:	27	Preliminary Approval:	
Date:	13-5-30	Date:	15-5-21	Date:	

[	Rev	Date	Change	Revised by	10	Approved
	Α	10.04.20	New Issue	KJ (	XX	
_					T	• • • • • • • • • • • • • • • • • • • •





D Ø0.191 -5.00 R0.50 4 PL R0.10 2 PL 0.63<sup>+0.00</sup> -0.05 0.813 R1.125 REF 2.56 REF Ø0.194 0.75 R1.438 D4021-9 BUSHING 2.500 **D4021-7 HOOP** 

MP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.		D4021 <sub>SHE</sub>	ET 3 OF 3
APPROVED	I NAP.	TITLE	SCALE
DE APPR.	1	MISC PARTS - 350 BASKET	NTS
DATE 10.04.06		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS SOCIALIST SEPRIATE AND COMPOSITION, AND IS CUMPLED ON THE DIPPLESS CONDITION THAT IT IS ADD TO SELUSED FOR ANY PAPPOSE OR OF DIPPLESS AND AND ANY PAPPOSE OF THE DIPPLESS AND THE DIPPL	

NOTES: 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B

-9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 REF DART SPEC M304R

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT -7: 0.80 lbs
-9: 0.02 lbs

8 .

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